

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018265**Date Inspected:** 31-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

This QA Inspector randomly observed the following work in progress.

BAY # 14

OBG 13EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037748 performing the Shielded Metal Arc Welding process on weld 011 located at PCMK SEG3011C. ZPMC QC Mr. Li Lv Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067609 performing the Shielded Metal Arc Welding process on weld 012 located at PCMK SEG3011E. ZPMC QC Mr. Li Lv Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037723 performing the Shielded Metal Arc Welding process on weld 011 located at PCMK SEG3011J. ZPMC QC Mr. Li Lv Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-fcm-1.

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054013 performing the Shielded Metal Arc Welding process on weld 114 located at PCMK SEG3011B. ZPMC QC Mr. Li Lv Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201087 performing the Shielded Metal Arc Welding process on weld 011 located at PCMK SEG3011C. ZPMC QC Mr. Li Lv Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037705 performing the Flux Cored Arc Welding process on weld 044 located at PCMK SEG3011H. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067993 performing the Flux Cored Arc Welding process on weld 064 located at PCMK SEG3011B. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044795 performing the Flux Cored Arc Welding process on weld 003 located at PCMK SEG3009S. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067079 performing the Flux Cored Arc Welding process on weld 054 located at PCMK SEG3009S. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-u4b-f.

### OBG 14EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044824 performing the Flux Cored Arc Welding process on weld 011 located at PCMK SEG3019AY. ZPMC QC Mr. Zhang Lin was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F) Repair-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 062406 performing the Submerged Arc Welding process on weld 002 located at PCMK SEG3019AP. ZPMC QC Mr. Zhang Lin was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044771 performing the Submerged Arc Welding process on weld 288 located at PCMK SEG3019AL. ZPMC QC Mr. Zhang Lin was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening, member identified as splice weld between anchorage plate AP3006 and AP3007. Distortion appeared to be caused by welding. Weld number identified as SEG3019AQ-024. ZPMC Quality Control (QC) inspector identified as Mr.

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Zhang Lin was present to monitor the heat straightening process. The heat straightening appeared to comply with heat straightening Report HSR1 (B)-9704.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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